

Date: Wednesday, 12/11/2008 1:31:32 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 1/4 TURN FASTNER RAIL (BLACK)
Job Number : 43343	
Estimate Number : 10096	
P.O. Number :	Part Number : D103858B
This Issue : 12/11/2008 S.O. No. :	Drawing Number : D1038
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 41592	Material :
Written By :	Due Date : 19/11/2008 Qty: 80 Um: Each
Checked & Approved By : <u>JLD 08.11.12</u>	
Comment : Est: E 03.05.02 Reformat; Added label KJ/RF	
Est Rev:F 06-08-16 Updated Packaging Procedures JLM	
Est Rev:G 08-09-16 Added Folio # JLM Verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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H for JLD 08.12.12



Comment: DOCUMENT CONTROL

Create white labels and bag them

2.0	D2023	Extrusion, Fastener Rail
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Comment: Qty.: 1.9030 f(s)/Unit Total : 152.2400 f(s)
 Extrusion, Fastener Rail

+ Scrap. DP. 05/11/16
B21907 Rf 05/11/15

3.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

SP 05/11/16

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA783 Rev: HA & Dwg D1038 Rev: B

2-Deburr per dwg D1038

PTO → *SP 05/11/15* *SP 05/11/15*


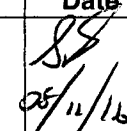

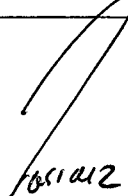

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D1038-58B PAR #: N/A Fault Category: Prod/Machine PAKS NCR: (Yes) No DQA: D Date: 08/12/22
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 08/12/23

NCR: 43343		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/11/16	4.0	1 part are scrap because of the hole on one side his off. R.C. operator didn't didn't put at the good place on the vise.	 05/11/16	Scrap and Destroy and replace Qty x1 Bkt 21507	 05/11/16	 05/11/17	 05/11/17	 05/11/17

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 08/11/17

7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/11/20 (91)

S 08/11/20 (91) counters

9.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
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Comment: Sub-Contracting OUTSIDE SERVICES
Issue P/O: 7439
Black Anodize as per Dwg D1038

08/11/20 (91)

91 PC

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage

PC 8/12/02 (91)

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: Inspect Anodize. Place in foam to protect anodize

S 08/12/02 (91) counters

12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389
Batch: 11/09420

2-Grind wire flush and deburr

3-Clean

08/12/11 (91)

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



coales

Comment: INSPECT WORK TO CURRENT STEP

S 08/12/22 (91)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Roll Part in foam .

3-Install red cap at each end and secure with tape.

4-Apply white labels to cardboard tubes

5-Identify and Stock

Location: _____

P 8/12/22 (91)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.12.22

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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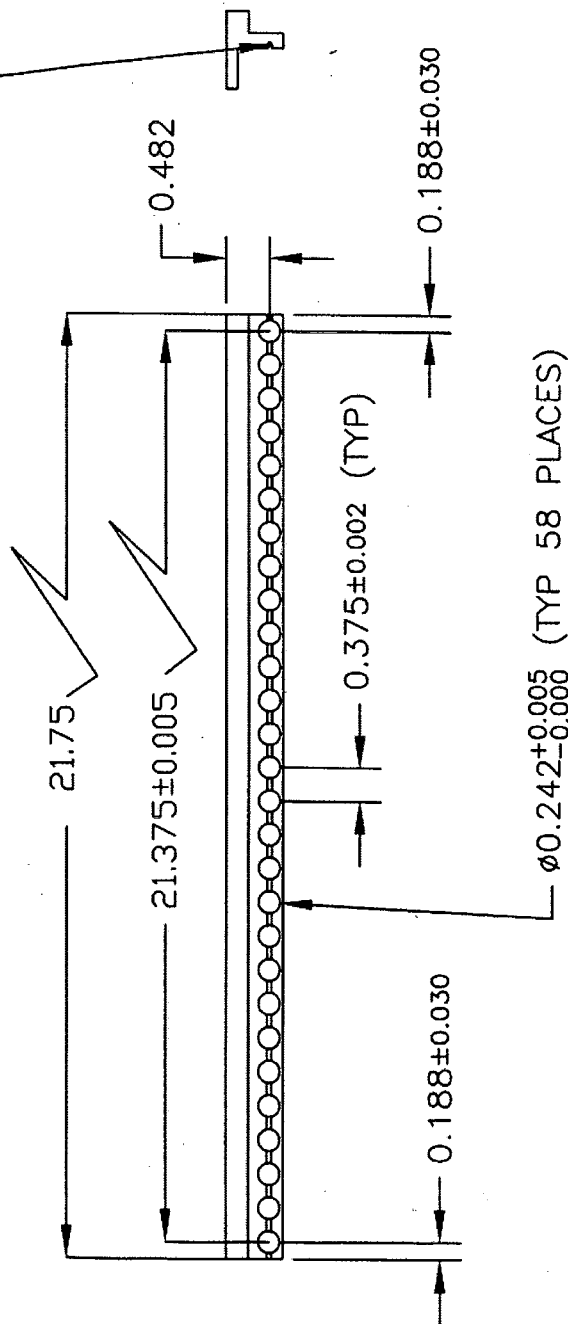
DART

DESIGN 94	DRAWN BY 94	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 94	APPROVED 94	DRAWING NO. D1038	REV. B SHEET 1 OF 1
DATE 05.02.02		TITLE 1/4 TURN FASTENER RAIL	SCALE NTS
	91.05.05	NEW ISSUE	
A	04.05.14	UPDATE TOLERANCE	
B	05.02.02	REDRAWN, UPDATE NOTES	

RELEASED

05.03.31 #

STAKE $\phi 0.50$ TYPE 302 STAINLESS
STEEL WIRE FULL LENGTH
(REF DART SPEC M302SW.050)



D1038-58 1/4 TURN FASTENER RAIL

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43343

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NOTE: Date & initial all entries

TNM ANODISATION et PEINTURE TNM INC.

21 chemin de l'Aviation, Pointe-Claire, QC H 9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

Certifié NADCAP certified

PACKING

SLIP

70549

01-Dec-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

NO. DE COMMANDE:

PURCHASE ORDER/

100602/7639

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	
1	91	91	D103858B	B 3343

S
05/12/02

PICKED UP BY / RECU: _____

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines r sponsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

TNM

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

70549

01-Dec-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

NO. DE COMMANDE:
PURCHASE ORDER/ 100602/7639



Conformance
Nadcap
Chemical Process
Nondestructive Testing

ITEM	COMMANDE ORDERED	EGRETE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
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1	91	91	D103858B B43343	
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BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2
ALL OVER

S
06/12/02

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: _____

☐ Directeur de la Qualité / Q.A. Manager ☐



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Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certifié

Certifié NADCAP certifié

**FACTURE
INVOICE****70549 Rev.00**

01-Dec-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

NO. LE COMMANDE: 100602/7639
PURCHASE ORDER/**CONDITIONS / TERMS:****NET : 0 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER	DESCRIPTION	PRICE UNITAIRE UNIT PRICE	EXTENSION
1	91	91	D103858B	B43343	\$0.00	\$0.00
				LOT PRICE		\$450.00
				<i>S</i> <i>0212102</i>		
				SUB TOTAL:		\$450.00
				TPS/GST:		\$22.50
				TVQ/PST:		\$0.00
				TOTAL AMOUNT DUE:		\$472.50

No de TPS / GST # : 891559734 RT

No de TVQ / QST # : 1019307154 TQ000

CERTIFICAT DE CONFIRMATION EMIS POUR CHAQUE PROCEDURE
CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS*En cas de perte ou de dommages dû à la valeur intrinsèque de certaines responsabilités se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.**Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.*